

Work Order ID 74679

Wednesday, October 05, 2011 8:58:04 AM



Page 1

Item ID: D6101-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Billet

Start Date: 10/5/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 80.00

Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D6101

Rev B

100

0.00



Purchasing

PURCHASING

Memo

0.00

Issue P/O: *15095*

- a) Description: Alluminum billet
- b) 6.00" x 6.250" x 2.00" thick
- c) Tolerance on length are +0.030"/-0.000" /E+/-0.008"
- d) Grain direction along 6.00" length
- e) Material: 7075-T7351 (QQ-A-250/12)
- f) Material certification required

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Ensure material certification is attached

11-10-5
(80)

11/14/14 *(80)*

Work Order ID 74679

Wednesday, October 05, 2011 8:58:04 AM

Page 2

Item ID: D6101-001

Accept

Revision ID:

Item Name: Saddle Billet

Start Date: 10/5/2011 Start Qty: 80.00

Required Date: 10/28/2011 Req'd Qty: 80.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

Ensure Material certification comply to Dwg D

0.00

130

Identify as per dwg & Stock Location: ENC

0.00



Packaging

Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/10/18
RF 11-10-19

Picklist Print

Wednesday, October 05, 2011 8:58:01 AM

Work Order ID: 74679

Parent Item: D6101-001

Parent Item Name: Saddle Billet





Start Date: 10/5/2011

Start Qty: 80.00

Required Date: 10/28/2011

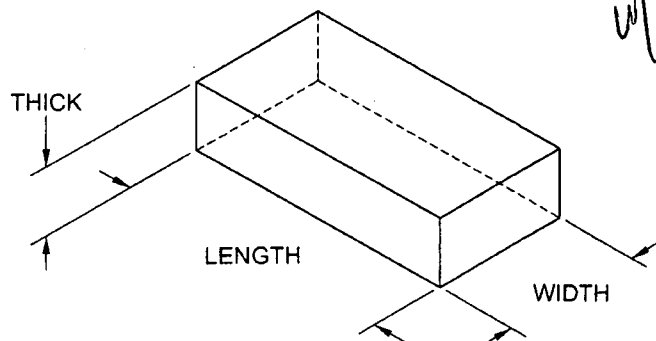
Required Qty: 80.00

Comments: IPP B: 101.05.04 New Issue IEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001P  7075-T7351 2X6X6.25		Purchased	No			110	Each	0.0000	1 	80			

Rec'd 10/14/11 (80)

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH X WIDTH X THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length ✓
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.05.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G

No: PEC 733537
Ship Date 14Oct11 at 16:50 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

B I L L O F L A D I N G

1) Our Order PEC-376093- 1 Your PO # 15095
ALUMINUM PLATE 7075T7351

2.00" THICK X 6.0000" X 6.2500"

*****D6101-001*****

Heat Number Tag No
708281 241823

Quantity PCS Wt LBS
20.83 SFT 80 623

2) Our Order PEC-376093- 2 Your PO # 15095
ALUMINUM PLATE 7075T7351

2.00" THICK X 6.2500" X 7.8750"

*****D6101-003*****

Heat Number Tag No
708281 241825

Quantity PCS Wt LBS
27.34 SFT 80 814

TOTAL: Tags PCS LBS
2 160 1437

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
** REFERENCED ON IT **

TOTAL (1,2) 2 SKIDS GW. 1648 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***
**** TEL. 800-926-2600 ****

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ETRE
RAPPORTEES IMMEDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

RECU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION
TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

DATE

8 / 1

9056691787

ThyssenKrupp

2011-Oct-12 01:58 PM

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

B I L L O F L A D I N G

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Via VIM TRANSFER
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Route 0- 0 Manifest
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ATTN: CHANTAL/LINDA

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** REFERENCED ON IT **

TOTAL (1,2) 2 SKIDS GW. 648 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***
**** TEL. 800-926-2600 ****

Page: 1Continued

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TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

DATE

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ThyssenKrupp

2011-Oct-12 01:59 PM

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THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship To: (1)
DART AEROSPACE

B I L L O F L A D I N G

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Ship Date 14Oct11 at 16:50 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

B I L L O F L A D I N G

* WE STOCK STAINLESS STEEL *
* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE
ADDED TO EVERY ORDER.***

Page: 2 Last

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.
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REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION
TVQ/GST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

DATE

9056691787

ThyssenKrupp

2011-Oct-12 01:59 PM

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Sold To: (20115)
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REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION
TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

DATE

9056691787

Thyssenkrupp

2011-Oct-12 02:00 PM

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein. Including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per

Valcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thoin
Quality Assurance Manager

Page 1 of 2

1292846	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item
2011-09-26	6375246	00000	1000320482-5	DS-20482-02-2
P.O. No./Govt Contract No.	Customer	Alcoa Item		
5400113144 Ln#: 0030	COPPER & BRASS SAL G041120093R04			

Ship To: COPPER & BRASS SALES INC
FRESNO BRANCH
5450 E HOME
FRESNO 93727 CA

Item Description
2.0 IN TK (+.055 -.055) X 52.5 IN W (+.3125 - 0.000) X 144.5 IN LN (+.5 -0.0) (N) A/T 7075- T7351 RECTANGLE-MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES, SAWED. AMS-QQ-A-250/12 IS 2007 EXC MRK AMS-STD-2154 IS 2010 EXC MRK AMS407B REV G EXC MRK ASTM209 REV 10 EXC MRK BSS7055 REV A EXC MRK MMS159 REV P ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-40 % US1 CL A 3 MM CQR 0231073 REV 02 CUST REQ 11-09-27 *** W/E 11-10-01 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector	Check Numbers
1	338534	708283	3093	2	PC	47111	
2	338536	708281	3093	2	PC	47111	
3	338537	708281	3097	2	PC	47111	
4	338548	708281	1550	1	PC	47111	
			10833	7			

Notes for CQR: 0231073.2
PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.

CQR: 0231073.2 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	57.0	6

MAILED TO: ThyssenKrupp
COPPER NO. 2401490407
BY: J.R.
COPPER & BRASS SALES INC

2011-Oct-12 02:00 PM ThyssenKrupp 9056691787

C/B

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

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Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1292848	0			
Ship Date	B.I. No.	Invoice No.	Alcoa No.	Item
2011-09-26	6375246	00000	1000320482-5	DS-20482-02-2
P.O. No./Govt Contract No.	Customer	Alcoa Item		
5400113144 Ln#: 0030	COPPER & BRASS SAL G041120093R04			

Page 2 of 2

CQR: 0231073.2 -Specification Limits (cont.)
T7351 Elec. Cond. (EC) % MIN 38.0 PCT

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Max		0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min				1.2		2.1	0.18	5.1				REMAIN

Alloy 7075,
Lot: 708281, - Mechanical, Physical, Metallography, Quantometer Results

No->		UTS	TYS	EL4D
Test		KSI	KSI	PCT
Temp Dir				
T7351 Long Transv.	3	71.4	60.8	10.6
		71.1	60.7	10.5
		71	60.3	10.5

T7351 Elect Cond %IACS 41.2 41.5 41.3 PCT

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9370105.	Actuals	0.08	0.30	1.6	0.02	2.5	0.18	5.6	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.972.1(a)]; it was manufactured in the United States

2011-Oct-12

02:00 PM

ThyssenKrupp

9056691787

6/8

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

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Valcolm Murphy
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Terrence Thom
Quality Assurance Manager

1292848 Ship Date	0 B.L. No.	Invoice No.	Alcoa No.	Item
2011-09-26	6375246	00000	1000320482-5	DS-20482-02-2
P.O. No./Govt Contract No.		Customer	Alcoa Item	
5400113144 Ln#: 0030		COPPER & BRASS SAL	G041120093R04	

Page 1 of 2

Ship To: COPPER & BRASS SALES INC
FRESNO BRANCH
5450 E HOME
FRESNO 93727 CA

Item Description
22.0 IN THK (+.055 -.055) X 52.5 IN W (+.3125 -
0.000) X 144.5 IN LN (+.5 -.001) (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED. AMS-QQ-A-250/12-1S 2007 EXC MRK AMS-STD-
2154 IS 2010 EXC MRK AMS4078 REV G EXC MRK
ASTMB209 REV 10 EXC MRK BSS7055 REV A EXC MRK
MMS159 REV P ((MARKED)) KRAFT PAPER
INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-40 % US1 CL
A 3 MM CQR 0231073 REV 02 CUST REQ 11-09-
27 *** W/E 11-10-01 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	338534	708281	3093	2	PC	47111
2	338536	708281	3093	2	PC	47111
3	338537	708281	3097	2	PC	47111
4	338548	708281	1550	1	PC	47111
			10833	7		

Notes for CQR: 0231073.2

PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.

CQR: 0231073.2 -Specification Limits

Temp	Dir	UTS	UTS	ELAD
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	69.0	57.0 6

SOLD TO: ThyssenKrupp
SHIPPER NO: 2401490449
BY: [Signature]
COPPER & BRASS REPRESENTATIVE

2011-Oct-12 02:01 PM ThyssenKrupp 9056691787

7/8

2011-Oct-12 02:01 PM ThyssenKrupp 9056691787

8/8

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

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Per:

Malcolm Murphy

Director of Manufacturing Davenport Works

Terrence Thom

Quality Assurance Manager

Page 2 of 2

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P.O. No./Govt Contract No.	Customer	Alcoa Item		
5400113144 Ln#: 0030	COPPER & BRASS SAL G041120093R04			

CQR: 0231073.2 -Specification Limits (cont.)

T7351 Elec. Cond. (EC) % MIN 38.0 PCT

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 7075	Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Lot: 708281	Min			1.2		2.1	0.18	5.1			REMAIN

Test: Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No-->	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T7351	Long Transv.	3	71.4	60.8	10.6
			71.1	60.7	10.5
			71	60.3	10.5

T7351 Elect Cond %IACS 41.2 41.5 41.3 PCT

Cast Number	Chemical - OBS	SI	FE	CU	MN	MG	CR	ZN	TI
H9370105	Actuals	0.08	0.30	1.6	0.02	2.5	0.18	5.6	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.972.1(a)]; it was manufactured in the United States

